

Work Order ID 74353

Wednesday, September 28, 2011 3:25:08 PM

Page 1

Item ID: D2661-1

Accept

Revision ID:

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/28/2011 Start Qty: 20.00

Required Date: 10/7/2011 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan: MLJ

Date: 11/09/28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2661

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ Fixturing Inspection last completed 11/10/14 by BA ☐ 1-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet ☐ 2-Machine Step No 2 of Folio and visually inspect as per attached Dimension

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74353



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Wednesday, September 28, 2011 3:25:08 PM

Item ID: D2661-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/28/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

11-10-18



QC

Memo

0.00

Quality Control



140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

9x8 m-11/10/18

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200F

10:00

9:30

9x8 m-11/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74353

Wednesday, September 28, 2011 3:25:08 PM



Page 3

Item ID: D2661-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/28/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

9 12 11-10-19.

170

Identify as per dwg & Stock Location: GTN70 0.00



Packaging

Memo

0.00

Packaging

9X 8p 11-10-19.

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/19
CMF
11-10-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 28, 2011 3:25:17 PM

Page 1

Work Order ID: 74353



Parent Item: D2661-1



Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/28/2011

Required Date: 10/7/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: C00.11.01 Removed P/O for Powder Coat - in house process EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-003		Manufactured	No			100	Each	73.0000	1	20			
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Saddle Billet, 7075



Location	Loc Qty	Loc Code
MAT040	8	
72226	8	
MAT44	65	
72226	5	
73769	60	

B 73775

9.0

B.A 11/10/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 74358
Description: 206 Saddle, Outboard, Right side		Part Number: D2661-2
Inspection Dwg: D2661 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				Date
				1	2	3	4	
A	0.100	0.140		0.105	0.110	0.112	0.110	
B	0.100	0.140		0.110	0.110	0.110	0.110	
C	1.250	1.270		1.137	1.133	1.126	1.1343	
D	0.615	0.685		0.675	0.675	0.675	0.675	
E	0.240	0.260		0.246	0.246	0.247	0.250	
F	1.437	1.467		1.320	1.320	1.313	1.320	
G	0.210	0.230		0.219	0.220	0.210	0.220	
H	0.100	0.180		0.135	0.135	0.135	0.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	
J	1.565	1.585		1.577	1.572	1.566	1.570	
K	0.235	0.240		0.238	0.238	0.238	0.238	
L	0.100	0.120		0.112	0.112	0.112	0.112	
M	0.990	1.010		0.999	0.999	0.999	0.999	
N	0.510	0.515		0.512	0.512	0.512	0.512	
O	5.990	6.010		5.999	5.999	6.000	5.997	
P	1.245	1.255		1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.313	0.318		0.315	0.315	0.315	0.315	
S	0.315	0.322		0.317	0.317	0.317	0.317	
T	2.495	2.505		2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	
V	0.787	0.807		0.799	0.799	0.799	0.799	
W	0.540	0.560		0.545	0.549	0.550	0.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	
Y	0.257	0.262		0.258	0.258	0.258	0.258	
Z	0.912	0.932		0.920	0.920	0.920	0.920	
AA	0.490	0.510		0.494	0.501	0.500	0.497	
AB	0.178	0.198		0.188	0.188	0.188	0.188	
AC								
AD								
AE								
AF								
Accept/Reject								

Measured by: BA	Audited by: J
Date: 11/10/17	Date: 11-10-18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order:	74253
Description: 206 Saddle, Outboard, Left side	Part Number:	D2661-1
Inspection Dwg: D2661 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	48		
A	0.100	0.140		0.111	0.110	0.110	0.110		
B	0.100	0.140		0.110	0.111	0.110	0.110		
C	1.250	1.270		1.1397	1.132	1.133	1.135		
D	0.615	0.685		0.675	0.675	0.675	0.675		
E	0.240	0.260		0.247	0.250	0.250	0.250		
F	4.437	4.467		1.320	1.321	1.320	1.320		
G	0.210	0.230		0.222	0.220	0.220	0.220		
H	0.100	0.180		0.135	0.135	0.135	0.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.578	1.572	1.573	1.575		
K	0.235	0.240		0.238	0.238	0.238	0.238		
L	0.100	0.120		0.112	0.112	0.112	0.112		
M	0.990	1.010		0.999	0.999	0.999	0.999		
N	0.510	0.515		0.512	0.512	0.512	0.512		
O	5.990	6.010		5.999	5.997	5.997	5.999		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.315	0.315	0.315	0.315		
S	0.315	0.322		0.317	0.317	0.317	0.317		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.799	0.799	0.799	0.799		
W	0.540	0.560		0.550	0.550	0.550	0.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.258	0.258	0.258	0.258		
Z	0.912	0.932		0.920	0.920	0.920	0.920		
AA	0.490	0.510		0.498	0.500	0.499	0.499		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	B.A
Date:	11/10/17

Audited by:	SL
Date:	11-10-18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 74353
Description: 206 Saddle, Outboard, Left side	Part Number: D2661-1
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.110					
B	0.100	0.140		0.109					
C	1.250	1.270		1.133					
D	0.615	0.685		0.675					
E	0.240	0.260		0.251					
F	1.437	1.467		1.321					
G	0.210	0.230		0.220					
H	0.100	0.180		0.135					
I	2.470	2.510		2.490					
J	1.565	1.585		1.573					
K	0.235	0.240		0.238					
L	0.100	0.120		0.112					
M	0.990	1.010		0.999					
N	0.510	0.515		0.512					
O	5.990	6.010		5.998					
P	1.245	1.255		1.250					
Q	2.495	2.505		2.500					
R	0.313	0.318		0.315					
S	0.315	0.322		0.317					
T	2.495	2.505		2.500					
U	1.357	1.367		1.362					
V	0.787	0.807		0.799					
W	0.540	0.560		0.550					
X	1.674	1.684		1.679					
Y	0.257	0.262		0.258					
Z	0.912	0.932		0.920					
AA	0.490	0.510		0.494					
AB	0.178	0.198		0.188					
AC									
AD									
AE									
AF									
Accept/Reject									

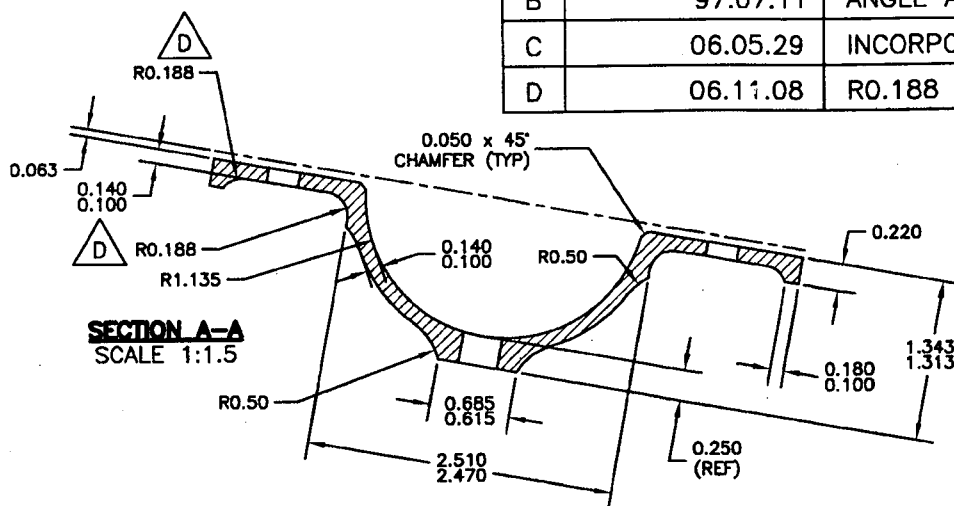
Measured by: D.A.
Date: 11/10/17

Audited by: [Signature]
Date: 11-10-18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

DESIGN	#	DRAWN BY	CB	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	PH	APPROVED	#	DRAWING NO.	REV. D
				D2661	SHEET 1 OF 1
DATE	06.11.08			TITLE	SCALE
				SADDLE OUTSIDE	1:3
A	97.03.25	NEW ISSUE			
B	97.07.11	ANGLE AND NOTES ADDED			
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095			
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$			

**RELEASED**

07-0310P-11

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

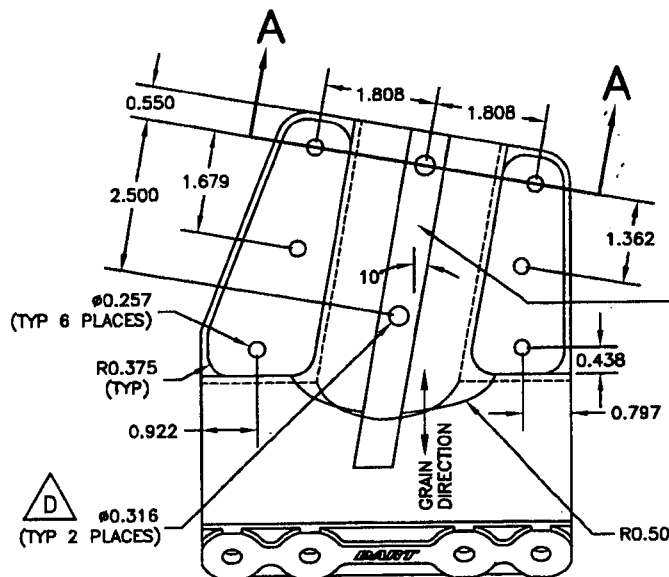
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M.L.J.

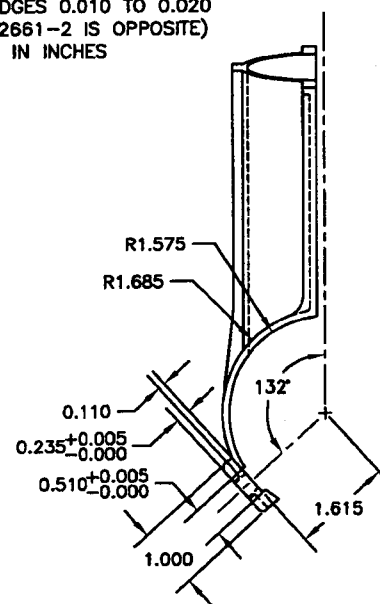
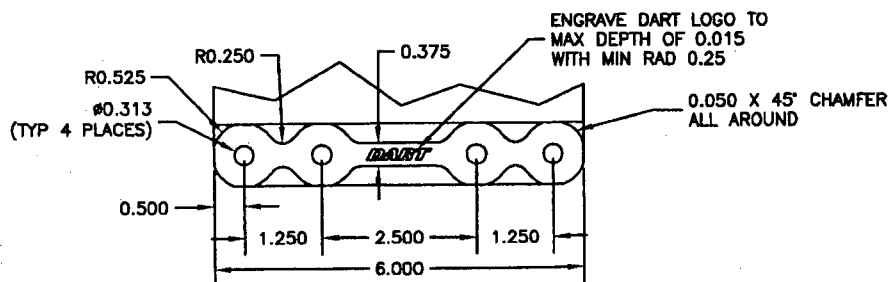
11/09/28

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2661-1 SHOWN (D2661-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010

**D2661-1 SADDLE OUTSIDE****Copyright © 1997 by DART AEROSPACE USA, INC.**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries